

WK 5/35

SPLK

DART AEROSPACE LTD		Work Order:	23978
Description: Wearpad		Part Number:	D2648-3
Dwg: D2648 Rev. D		Qty:	400
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Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller RF 02.08.12 Dwg not required	SD	05.08.08	400
2	PG	Issue P/O: 200 8447 Email or ship DXF file to vendor Make per Drawing D2648-1 Material release note required	U	05.08.10	400
3	RG	Receive and Inspect for transit damage Ensure the material release note attached	CJ	05/08/25	400
4	QC6	Inspect dimensions	AM	05/08/25	400
5	GA	Deburr if necessary			
6	GB	Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326 and identify as D2648-3	SB	05/09/01	401
7	WS	Weld as per Dwg D2648 using Jig DT 8210 Qty Description Batch A/R 7560Hardcoat M17914			192
8	WS	Remove any weld that penetrated through Wearpad if necessary	CPL	05/09/16	
9	QC9	Inspect weld	CPL	05/09/16	192
10	QC5	Inspect work to Step 9	AM	05/09/27	192
11	FP	Powder Coat Grey (RAL-7012) (Ref. 4.3.5.5) per QSI 005 4.3	AM	05/09/27	192
12	QC3	Inspect Powder Coat	AM	05/10/20	192
13	FP	Identify and Stock	AM	05/10/20	192
14	AC	Cost / part 6.05	AM	05/10/21	192
15	DC	Close W/O 5.93 Inspect Level 21	AM	05/10/24	192

Rev	Date	Change	Revised By	Approved
A	97.12.04			
B	99.04.09	Re-format	DM	
C	00.06.22	Removed P/O for powder coat	EC	
D	00.11.15	Removed Bending	EC	
E	02.09.18	Re-format; Incorporated D2648-1	KJ RF	

RELEASED
02/09/19 RF



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TEST CERTIFICATE

Ref. 5078/21785

CUSTOMER	Wilkinson	SPECIFICATION ASTMA1008 CS Type A												CERTIFICATE No TC109561										
CUSTOMER O/N	90-21N-548	PRODUCT CRA WIDE COIL												PAGE	1 of 1									
MILL O/N	471159	DIMENSIONS 0.055" x 48" x Coil												DATE	23 April 2005									
PACK NUMBER	HEAT No	C x100	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B x10000	N2 x100	CE() 180°	BEND	YIELD	T.S.	%ELONG G.L.=	HARDNESS HRB	r ()	LENGTH (feet)
R9-457097-00	640590	4	TR	20	13	17	12	17	20	1	8	1	1					Good				46		1562
R9-457098-00	640590	4	TR	20	13	17	12	17	20	1	8	1	1					Good				46		1483
R9-457099-00	640590	4	TR	20	13	17	12	17	20	1	8	1	1					Good				46		1562
R9-457100-00	640590	4	TR	20	13	17	12	17	20	1	8	1	1					Good				46		1496
R9-457101-00	640590	4	TR	20	13	17	12	17	20	1	8	1	1					Good				47		1562
R9-457102-00	640590	4	TR	20	13	17	12	17	20	1	8	1	1					Good				47		1555

YIELD (A)=0.2% PROOF STRESS (B)=LOWER YIELD STRESS	GAUGE LENGTH (G.L.) (A)=200mm (B)=50mm	PLASTIC STRAIN RATIO (r) (A)=r0 (B)=r90 (C)=80mm (D)=5.65 x 50 (E)=2" (F)=8"	IMPACT TEST (A)=10mm x 10mm (B)=7.5mm x 10mm	(C)=5mm x 5mm (D)=2.5mm x 10mm (E)=5mm x 10mm	CARBON EQUIVALENT VALUE (CE) (A)=C+Mn/6 (B)=C+Mn/6+(C+V+Mo)/5+(Cu+Ni)/15 (C)=C+Mn/6+S/24 (D)=
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WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED *Batish Misra*
OC METALLURGIST

16 ga crms

